

Date: Thursday, 3/2/2006 3:05:44 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEB ASSEMBLY	
Job Number	: 26017		Part Number	: D2174041	
Estimate Number	: 10194		Drawing Number	: D2174-041 REV. D	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 3/2/2006 S.O. No. : N/A		Drawing Revision	: D	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 3/30/2006	
Previous Run	: N/A		Qty:	25	
Written By	<u>See JF COMMENT Below</u>		Um:	40	
Checked & Approved By	<u>JF 06-03-02</u>		Each		
Comment	: Est: D 04.06.10 Reformat; Changed Step 2 KJ/JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D21741	Web	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) Web	
		Qty Part Number Description Batch 1 D2174-1 Web B22192 (5) B210301 (1)	
2.0	D21751	Angle LH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) Angle LH	
		Qty Part Number Description Batch 1 D2175-1 Angle B24317 (6) B210301 (1)	
3.0	D21752	Angle RH	
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) Angle RH	
		Qty Part Number Description Batch 1 D2175-2 Angle B24317 (6) B210301 (1)	
4.0	MS20470AD46	Rivet, Universal Head	
		Comment: Qty.: 23.0000 Each(s)/Unit Total : 920.0000 Each(s) Rivet, Universal Head	
		Qty Part Number Description Batch 23 MS20470AD4-6 Rivet M17 566	 540 06:04:01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 05/04/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Assemble as per Dwg D2174-041

2- Identify as D2174-041

5/4/0

06/04/03

25

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/04/03 (25)

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST220

SP 06/04/03 (25)

10.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

DC 06/04/11 (25)

Job Completion



IN 06/04/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

ACOPY IS
MADE
BY DART

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

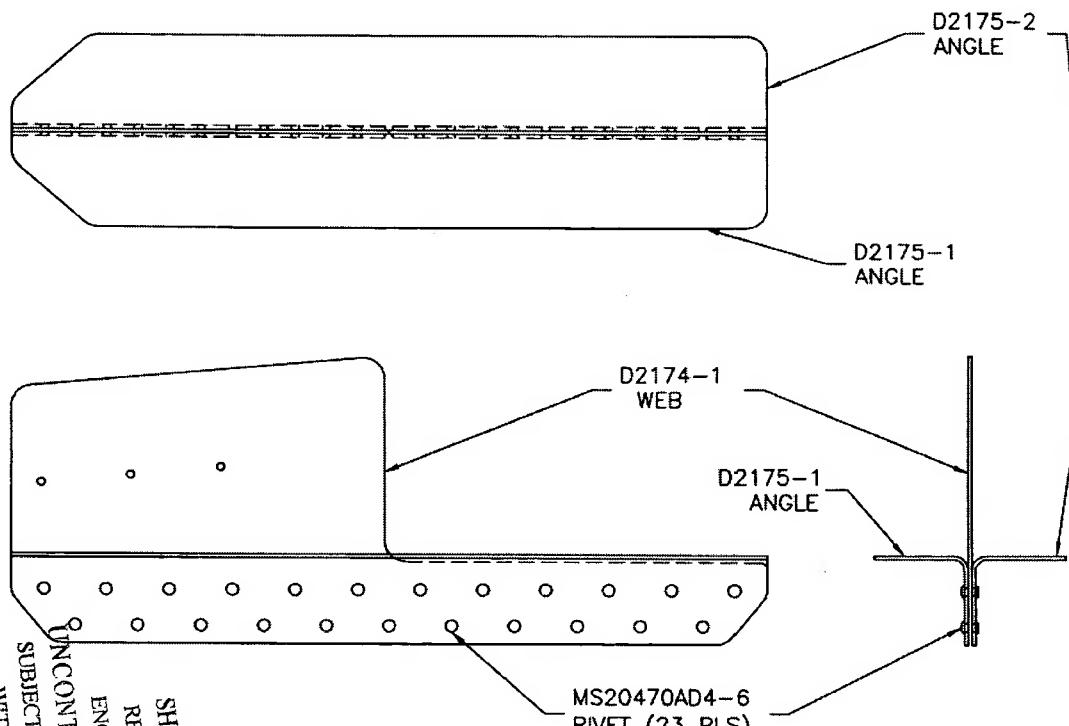
REV. D

DESIGN	DRAWN BY	
CHECKED	APPROVED	DRAWING NO.
		D2174-041
DATE	TITLE	SHEET 1 OF 1
04.06.03	WEB ASSEMBLY	1/3

RELEASED

04.06.03

A	95.10.25	NEW ISSUE
B	96.01.18	RE-DRAWN
C	00.09.11	UPDATE FINISH SPEC.
D	04.06.03	RE-DESIGN



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 26017

NOTES:

- C 1) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED